Work Order Wednesday, Septem												Page 1
Revision ID:	3651-1 asket			Accept					Setup	Start Stop		11
Start Date: 9/8 Required Date: 9/8 Reference:	1/2010 8/2010	Start Qty: 5.00 Req'd Qty: 5.00			Cust Item II Customer:	D:						
	Process Plan	::	Date: 10-9-0	✓ Tooling: SPC (Y/N):		nte:		J	Run	Start Stop:		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		leject lumber	Insp. Stamp
Draw Nbr D3651	Revis Rev I	sion Nbr								,	** **	
100  Waterjet  FLOW CNC Waterjet		FLOW WATER JET  Memo 1-Cut as if necessa	per Dwg D3651□Dwg Rev: ary	0.00 0.00 B_□Prog Rev:	<b>B</b> □2-Deburr			B	<u>u-</u> 9	- 3(	<b>(</b> 8)	
QC Quality Control		QC2- Inspect parts of  Memo	f machine FAI/FAIB	0.00				1图(	<u>0-9.</u>	-7(		
120 		QC8- Inspect parts - s	second check	ري کي کي 00.00	lorlez			48	)			- 101

Quality Control

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W/O:			WC	RK ORDER CHANG	ES			, ~
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQA:</b>	Date: _	
	Res	olution:	Disposition	1:	_ QA: N/C Cld	osed:	Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCR	)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
	0.2	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
			·					

#### Work Order ID 61748

Page 2

Wednesday, September 01, 2010 11:40:28 A

Item ID:

D3651-1

**Revision ID:** 

Item Name: Gasket

**Start Date:** 

9/1/2010

Start Qty: 5.00

Required Date: 9/8/2010



Accept

Setup Start

Stop



**Req'd Qty:** 5.00

**Cust Item ID:** 

**Customer:** 

Reference: Approvals:

Process Plan:

QC:

Date: Date:\_\_\_ Tooling:

SPC (Y/N):

Set Up/

Date:

Date:

Start Run

Stop



Sequence ID/

**Work Center ID** 

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00

Run Hours

0.00

Tool ID

Tool # Plan

Code Qty

Reject Accept Qty

Reject Number

Insp. Stamp

140

OC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10-9-22

W/O:		7/4 -77000_30	W	ORK ORDER CHANG	ES				
DATE	STEP	PRC	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
	Re	esolution:	Disposition	on:	_ QA: N/C C	osed:	V	Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC	12411	Corrective Action Section			ation	Approval	Approval
	0121	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector

### **Picklist Print**

Wednesday, September 01, 2010 11:40:32 AM

Work Order ID: 61748

Parent Item:

D3651-1

Parent Item Name:

Gasket



**Start Date: 9/1/2010** 

Required Date: 9/8/2010

Page 1

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A New Issue 07-09-27

IPP Rev:B ECN 1113P 08-01-22

DD verified by: EC DD verified by: EC

IPP Rev:C ecn1162

08-04-02

DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
G89		Purchased	No		-	100	sf	10.0000	0.4652	2.448421	3.8	)	
										BI	0-9-2	<b>}</b> (	

coated cloth

Loc Qty Location Loc Code mat50 10 109805 10

109808



W/O:			WC	RK ORDER CHANG	iES				موم و
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector
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	ļ								
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Res	olution:	Disposition	1:	QA: N/C (	closed:		Date: _	
NCR:		,	WORK ORDI	R NON-CONFORM	ANCE (NC	R)			
		Description of NC		Corrective Action Sect	tion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng			& Section C		QC Inspector
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	1								

DART AEROSPACE LTD	Work Order: 6/74	8
Description: Gasket	Part Number: D3651	-1
Inspection Dwg: D3651 Rev: B	Page 1	of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	-261	×		V IBOD	
0.40	+/-0.030	,390	٧		V	
6.69	+/-0.030	6,710	100		V	
5.25	+/-0.030	5.30	<b>⊠</b>		U	
9.59	+/-0.030	9.573	×		V	
8.13	+/-0.030	8,113	×		V	
4.48	+/-0.030	5,500	4		V	
3.00	+/-0.030	3,00	<b>&gt;</b>		V	
3.03	+/-0.030	3,034	6-		U,	
2.60	+/-0.030	2,676	7		V	
		·				
						_

Measured by: [#3	Audited by:	Prototype Approval: N/A
Date: 10-9-31	Date: 10/07/27	Date: N/A

Rev	Date	Change	Revised by	Approved
Α	08.04.17	New Issue	KJ/DD X	
			: ()	

SHOP CONT UNCONTROLL FIRE 8

D3651-043 FLANGE WELDMENT

INSTALL CR3523-4-02 OR NAS9307M-4-02 RIVET (58 PLACES)

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

#### D3651-041 AFT BASE ASSEMBLY

-D3651-11 GASKET

D3651-9 INSIDE DOUBLER

D

D3651-041 NOTES:

1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.6 Ibs

--D3651-1 GASKET

SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50, 0.88 WAS 0.98: REMOVED ANGLE SHEET 3: 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504 NEW ISSUE. Α REV. DESCRIPTION DESIGN RF

BY DATE DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA

RF

DRAWN RF DRAWING NO. CHECKED D3651 MFG. APPR. APPROVED TITLE DE APPR.

08.01.07

-D3651-13 OUTSIDE DOUBLER

DATE

08.01.07

07.11.07

REV. B

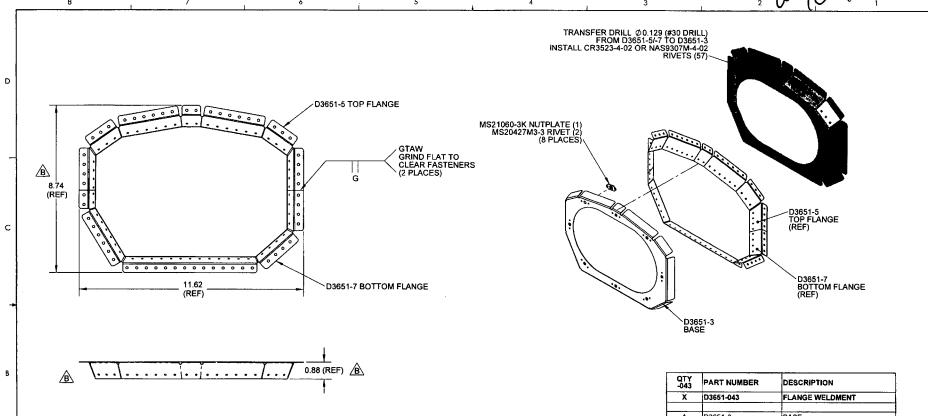
SCALE

SHEET 1 OF 9

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Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA:	Date: _	<del> </del>
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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D3651	_043	FI A	NGF	WEI	DMENT.

QTY -043	PART NUMBER	DESCRIPTION
Х	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET: CACEA
		4 8 9 7 W S E 1

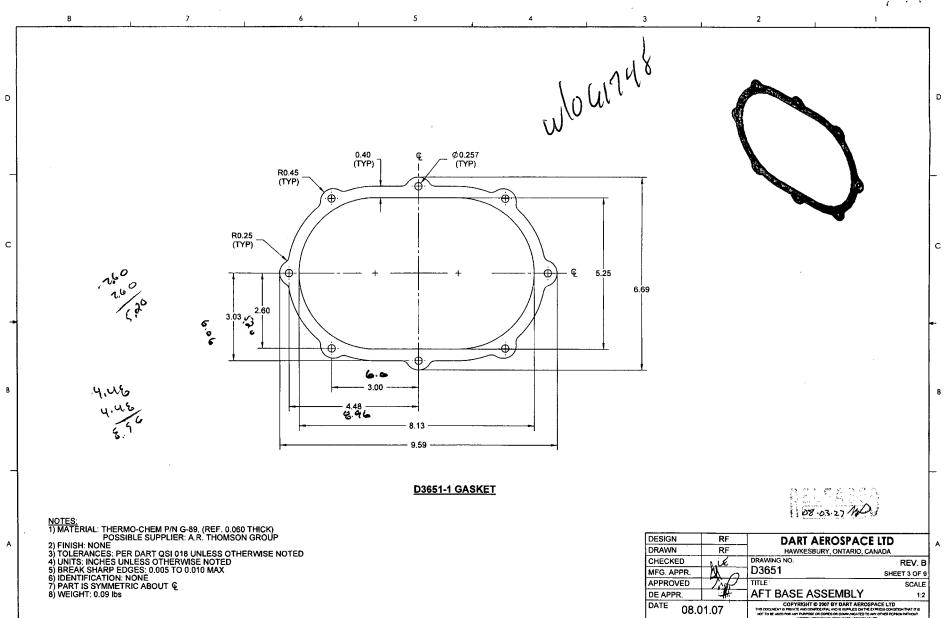
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DESIGN	· RF	DART AEROSPACE	LTD	Α
DRAWN	RF	HAWKESBURY, ONTARIO, CAN		^
CHECKED	.JE	DRAWING NO.	REV. B	
MFG. APPR.	MA C	D3651	SHEET 2 OF 9	
APPROVED	3/47	TITLE	SCALE	
DE APPR.	-#	AFT BASE ASSEMBLY	1:3	
DATE 08.0	01.07	COPYRIGHT © 2007 BY DART AEROSPA THIS DOCUMENT IS PRIVATE AND COMPORTIVE AND IS SUPPLIED ON THE EXP NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMANICATED TO MAY	RESS CONDITION THAT IT IS	

D3651-043 NOTES;
1) WELD PER QSI 004
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.76 lbs

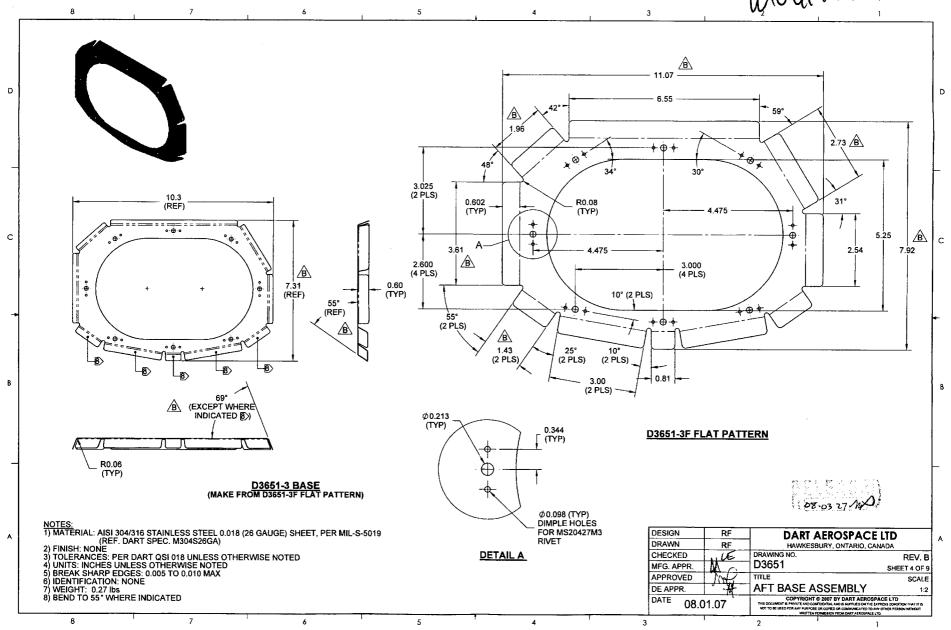
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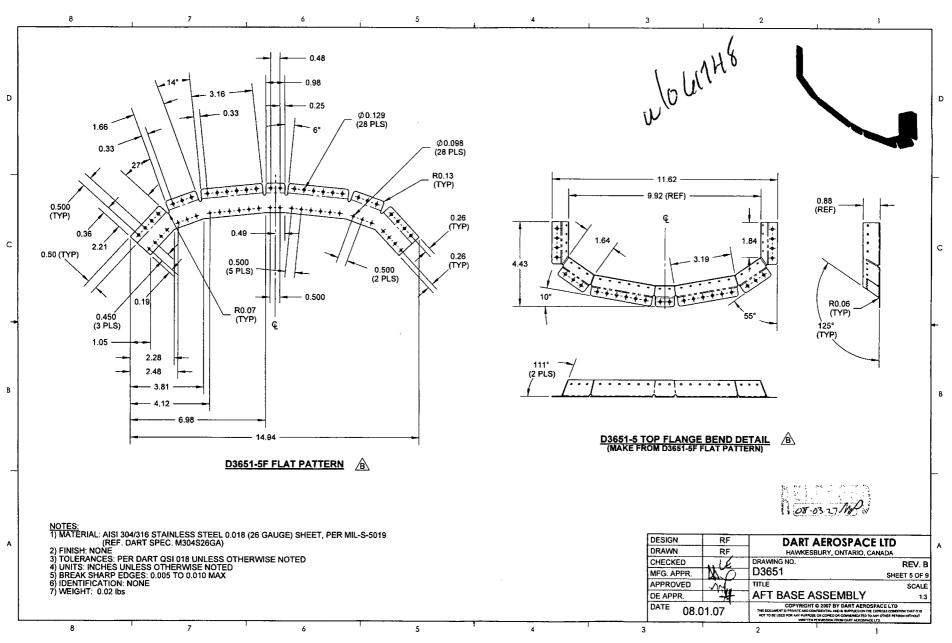


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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

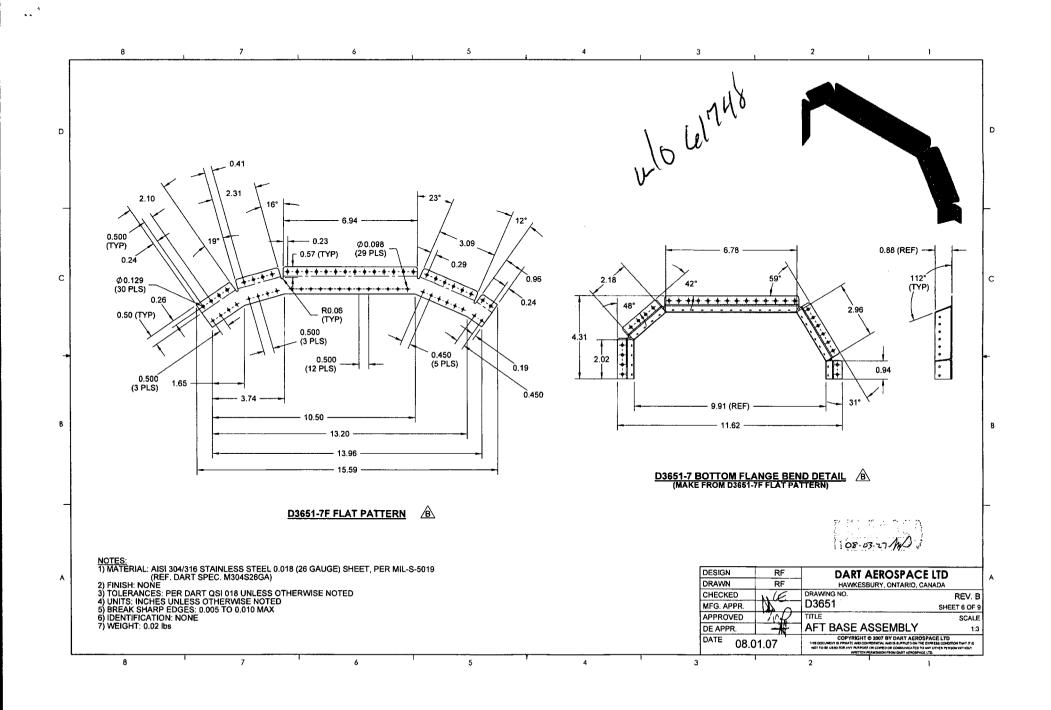
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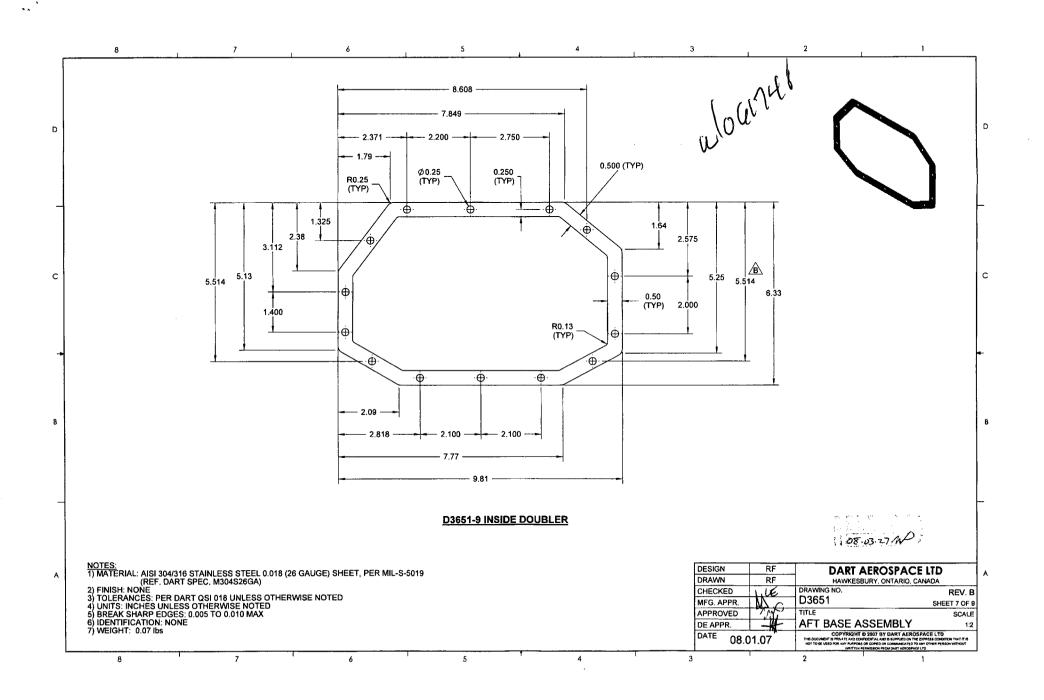
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector



W/O:			WC	RK ORDER CHAN	GES				,
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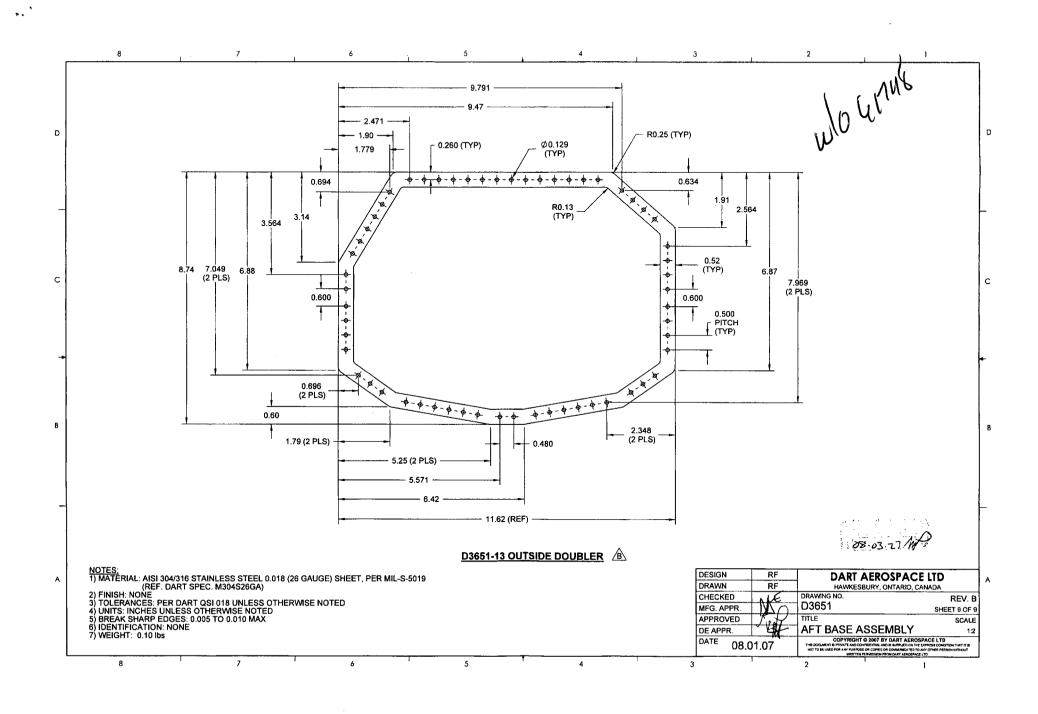
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wlounul 9 706 - 5.571 -0.480 5.20 (2 PLS) - 3.731 3.14 -- 2.081 Ø0.129 2.348 (TYP) (2 PLS) 0.500 (TYP) 1.79 (2 PLS) D D 1.41 0.696 (2 PLS) R0.25 (TYP) Ø0.250 (TYP) ·À — 2.100 — <del>- | -</del> — 2.100 – (TYP) 7.969 (2 PLS) 0.600 0.600 С 8.14 (2 PLS) 6.87 5.96 <u>.</u> 8.74 (2 PLS) 5.698 2.200 -- 2.750 7.049 (2 PLS) 5.636 3 564 0.250 (TYP) 3.698 6.08 6.96 3.14 · <del>(</del> · 🕁 · 2.564 4.236 3.67 1.62 1.373 3.00 0.634 0.260 (TYP) 1.41 1.779 1.90 2.020 — 2.471 → - 2.95 -- 3.284 9.47 9.521 10.22 NOTES:
1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.2 lb DESIGN RF DART AEROSPACE LTD D3651-11 GASKET B DRAWN RF HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED W REV. B D3651 MFG. APPR. SHEET 8 OF 9 TITLE APPROVED SCALE AFT BASE ASSEMBLY

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W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cat	egory:	NCR: Yes	lo DQA:	Date: _	
	Re	esolution:	Dispositi	on:	_ QA: N/C Clo	sed:	Date: _	
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DATE	0750	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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W/O:			WO	RK ORDER CHANGES	3			•
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